

5/29

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23603
<b>Description:</b> Bearpaw Kit (13" x 24")		<b>Part Number:</b>	K10006
<b>Dwg:</b> D2672 Rev. B1		<b>Qty:</b>	5 Kits
<b>Ref:</b> K10006 Rev. C; DSK086-2 Rev. A		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler <b>Note: (1) K10006 Kit consists of Qty (2) D2672F Dwg not required</b>	HJ	05.06.21	5																																																
2	DC	Photocopy bluefile: K10006 D206-559-023 D350-578-021 and create labels per PPP K10006 <b>CHG004</b> <b>(Bag Bluefiles separately)</b>	DK	05-07-04	5																																																
3	GA	<b>Cut 2 blanks per (1) K10006 Kit</b> Cut blank: 13.25" x 24.25" x 1.00" thick (+0.030/-0.000) per DSK086-2 Material: Black UHMW 1" (MUHMWB10) Batch: <u>M15926</u>	gml	05/09/27	5																																																
4	MV	Inspect material for defects or damage prior to machining	MS	05/09/27	5																																																
5	MV	Machine as per Folio and Dwg D2672 <b>Identify as D2672F</b>	MS	05/09/27	5																																																
6	QC2	Inspect parts as they come off the CNC machine	gml/MS	05/09/28	5																																																
7	MV	Deburr	MS	05/09/28	5																																																
8	QC8 & 5	Second inspection	J.L	05/09/28	5																																																
9	KP	<b>Pick: Packing Kit (Note: D2672F is on the BOM as material from step 3)</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B 21872</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B 22494</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B 22503</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B 22504</td></tr><tr><td>2</td><td>D2672F</td><td>Bearpaw</td><td>B 23603</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B 22505</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>M16067</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>M15422</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>M17566</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15924</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B 21872	12	D2274	Radius Block	B 22494	6	D2438	Clamp	B 22503	12	D2529	Washer	B 22504	2	D2672F	Bearpaw	B 23603	6	D2732-050	Rubber Cushion	B 22505	12	AN4-15A	Bolt	M16067	12	AN4-17A	Bolt	M15422	24	AN960JD416	Washer	M17566	12	MS21042L4	Nut (or -4)	M15924	1	Paperwork package from Step 2			CL	05/08/30	5
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10	QC4	Inspect Kit for 100% Completeness on the W/O	CL	05/09/28	5																																																
11	PK	Identify and pack for shipping as per PPP K10006	REV.D CL	05/09/28	5																																																
12	AC	Cost / part <u>281.35</u>	SVC	05-09-30	5																																																
13	DC	Close W/O <u>242.55</u> Inspect Level 21	CL	05/09/30	5																																																

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10006 created for Bearpaw Kit	EC	
B	00.06.30	Relaced D2639 by D2981-0200-1600 (MPP 2072)	EC	
C	01.03.19	CHG002 (MPP 2117)	EC	
D	03.05.30	Reformat; Incorporated D2672F	KJ/RF	
E	04.02.17	Tolerance added to Step 3	KJ/JLM	

RELEASED  
04.02.2017

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	23603
Description: Bearpaw		Part Number:	D2672
Inspection Dwg: D2672 Rev: B1		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750"	✓			
B	12.750	+/-0.030	12.750"	✓			
C	4.250	+/-0.010	4.253"	✓			
D	2.000	+/-0.030	1.987"	✓			
E	9.000	+/-0.010	9.000"	✓			
F	0.375	+/-0.030	.382"	✓			
G	9.000	+/-0.010	9.000	✓			
H	Ø0.260	+0.005/-0.000	Ø.260"	✓			
I	Ø0.93	+/-0.030	Ø.928"	✓			
J	0.300	+0.030/-0.000	.300"	✓			
K	0.625	+/-0.030	.625"	✓			
L	0.063 x 45°	+0.030/-0.010	.037"	✓			
M	0.250	+/-0.010	.257"	✓			
N	5.500	+/-0.030	5.506"	✓			
O	R0.250	+/-0.030	R.250"	✓			
P	0.200	+/-0.030	.197"	✓			
Q	0.25 x 45°	+/-0.030	.275"	✓			
R	0.950	+0.030/-0.010	.956"	✓			
S	0.375	+/-0.010	.375"	✓			

Measured by: <i>MS</i>	Audited by: <i>gm</i>	Prototype Approval:	N/A
Date: <i>Sept. 27/05</i>	Date: <i>05/09/27</i>	Date:	<i>N/A</i>

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue <i>P/O K10006</i>	KJ/RF	<i>[Signature]</i>

RELEASED

*R* 04.01.15

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 20, 2005  
03:23 pm

Work Order No : 0023603  
Project Name : K10006  
Project For : WK529  
Work Order Type : Main  
Main WO Number :  
House Part Number : \*K10006  
Description : Bearpaw Kit 13" x 24"  
Manufactured : Yes  
Amount Req'd : 5  
Amount Done : 0  
Start Date : 06-20-05  
Est Finish Date : 07-25-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00